



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4640-15
Job Sheet 183209



Part No: D4640-15

Job Qty: 2 ea

Part Name: Ceiling Protector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/13/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 8,9 IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC IPP REV:B 12.10.17 AS PER REV.B VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Waterjet		SC 18/09/19
100	Waterjet	2 pcs	9/21/18	9/21/18	0.00	0.56	Waterjet1		SC 18/09/19
110	QC	2 pcs	9/21/18	9/21/18	0.00	0.00	QC2		SC 18/09/19
120	QC	2 pcs	9/21/18	9/21/18	0.00	0.00	QC8		SEP 21 2018 68
130	Packaging	2 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3		SEP 21 2018 9-89
140	QC21-SA	2 Ea	9/21/18	9/21/18	0.00	0.00	QC21		SEP 21 2018 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MLEXS.093-F6006-07	GE Plastics Lexan Sheet (Light Grey)	32 sf (16 ea)	90-Start up Operation	5111169

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MLEXS.093-F6006-07	32	2,124	0

Part Specifications

Specifications could not be found.

Plex 9/13/18 2:41 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐		
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Large Fab ☐	Composite ☐	Supplier ☐																				
Date : _____		Disposition _____ _____			MRB (QSI042) Approval _____ _____																	
Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K6A 1K7 CANADA TEL.: 1 813 632 - 5200 Email: sales@dartero.com www.dartaerospace.com Date: 09/20/18 Container No: S111851 Part: D4640 - 15 Job No: 183209 Serial No/Batch: S111851 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's QC / QA Coordinator Approval _____ _____		Completed By _____ _____			Lead hand / Supervisor Approval Verification _____ _____																	
		QC / QA Coordinator Approval _____ _____																				
		CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:33%;">☐ Power Loss/Surge</td> <td style="width:33%;">☐ Positioned Wrong</td> </tr> <tr> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>			☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread
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Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐																				
OTHER : _____																						

DART AEROSPACE LTD		Work Order: 183209
Description: Ceiling Protector		Part Number: D4640-15
Inspection Dwg: D4640	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.80	+/-0.030	18.80	1		15C01	
22.03	+/-0.030	22.03	1		Tape	
20.06	+/-0.030	20.06	1			
13.06	+/-0.030	13.06	1			
3.60	+/-0.030	3.60	1			
8.09	+/-0.030	8.09	1			
20.86	+/-0.030	20.86	1			
3.11	+/-0.030	3.11	1			
7.27	+/-0.030	7.27	1			
5.10	+/-0.030	5.10	1			
4.85	+/-0.030	4.85	1			
13.06	+/-0.030	13.06	1			
1.50	+/-0.030	1.50	1			
5.00	+/-0.030	5.00	1			
57.46	+/-0.030	57.46	1			
82.37	+/-0.030	82.37	1			
Ø8.13	+0.012/-0.001	Ø8.13	1			
6.77	+/-0.030	6.77	1			
5.72	+/-0.030	5.72	1			
6.13	+/-0.030	6.13	1			
2.21	+/-0.030	2.21	1			
0.88	+/-0.030	0.88	1			
7.78	+/-0.030	7.78	1			
7.47	+/-0.030	7.47	1			
Ø0.375	+0.006/-0.001	Ø0.375	1			
9.73	+/-0.030	9.73	1			
21.00	+/-0.030	21.00	1			
31.28	+/-0.030	31.28	1			
4.00	+/-0.030	4.00	1			
27.23	+/-0.030	27.23	1			
22.28	+/-0.030	22.28	1			
20.36	+/-0.030	20.36	1			
0.093	+/-0.010	0.093	1			

Measured by: SC	Audited by: 68	Preliminary Approval:
Date: 18/09/19	Date: SEP 24 2018	Date:

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	
B	13.02.27	Dwg Rev updated	KJ	